

21

Date: Wednesday, 5/16/2007 8:13:12 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 32372		
Estimate Number	: 12530		
P.O. Number	: N/A	Part Number	: D35471
This Issue	: 5/16/2007 S.O. No. : N/A	Drawing Number	: D3547
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31124	Material	: N/A
Written By	:	Due Date	: 5/22/2007
Checked & Approved By	:	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-09-18 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S125	2024-T3 .125 sheet
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Comment: Qty.: 0.0557 sf(s)/Unit Total : 0.5565 sf(s)
2024-T3 .125 Sheet
(M2024T3S0125)
Batch: 4102087

SAD 07/06/01

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3547
Dwg Rev: A
Prog Rev: A
****Ensure Grain Direction is Correct*****

SAD 07/06/01

(16)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/01 (16)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07.06.04 (10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg D3557

SAD 07/07/12

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 32372

Part Number: D35471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-07-12 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-07-17

(10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

101575

07-07-17

(10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-07-17 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-07-18 (10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.18

Job Completion



07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32372
Description: Bracket		Part Number:	D3547-1
Inspection Dwg: D3547 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.313	+/-0.010	0.313	✓		Vern	
0.913	+/-0.010	0.910	✓		Vern	
2.054	+/-0.010	2.059	✓		Height gage	
2.38	+/-0.030	2.38	✓		Vern	
0.438	+/-0.010	0.437	✓		Vern	
2.813	+/-0.010	2.815	✓		Vern	
0.575	+/-0.010	0.579	✓		Vern	
1.100	+/-0.010	1.108	✓		Height gage	
1.625	+/-0.010	1.620	✓		Vern	
2.150	+/-0.010	2.155	✓		Height vern	
2.675	+/-0.010	2.680	✓		Vern	
3.25	+/-0.030	3.26	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.174	✓		Vern	
Ø0.323	+0.006/-0.001	Ø0.324	✓		Vern	
0.125	+/-0.010	0.124	✓		Vern	

Measured by:	SAD
Date:	07/06/01

Audited by:	SD
Date:	02.06.04

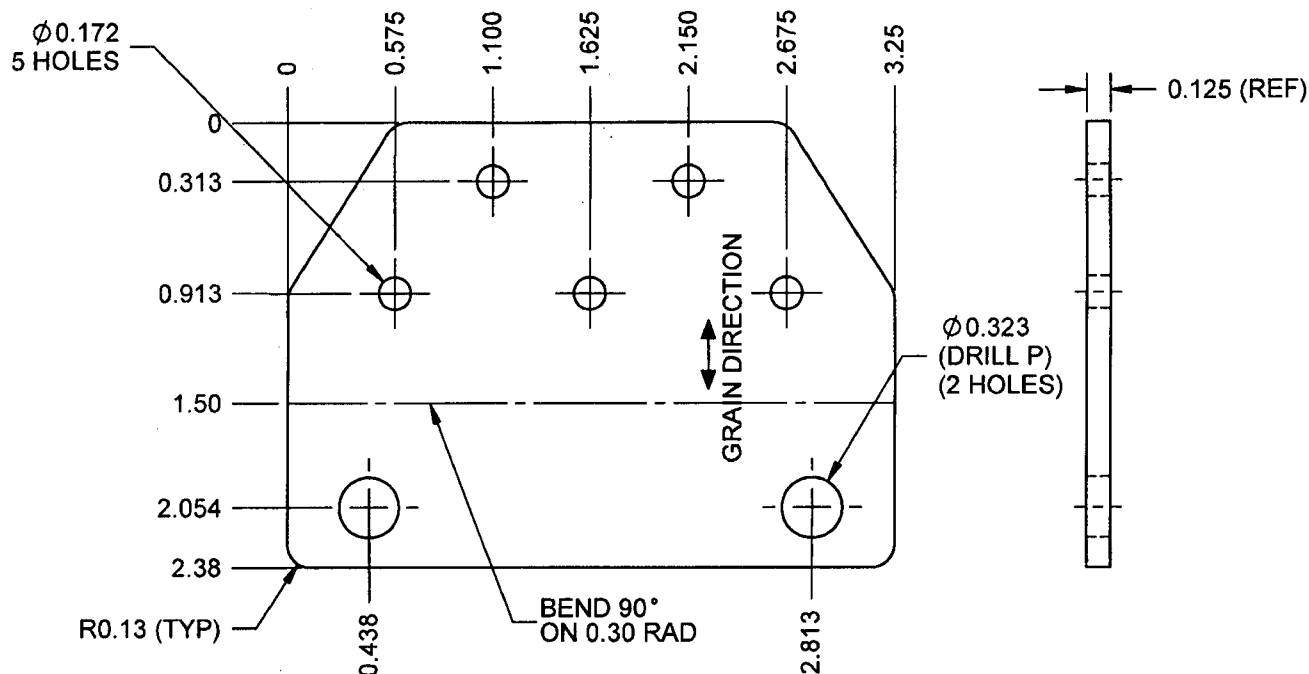
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	BE

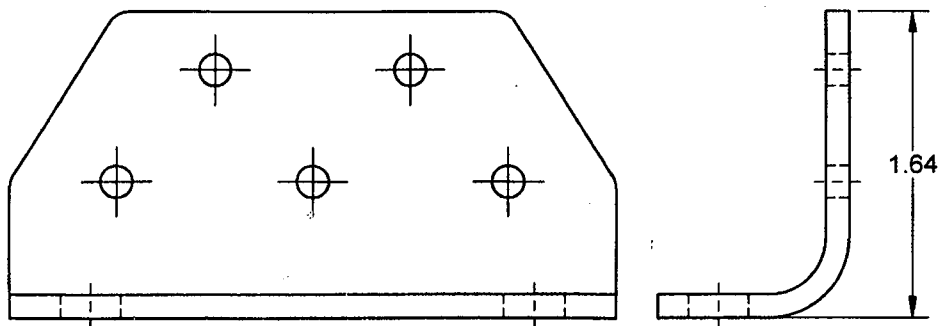


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D3547	REV. A SHEET 1 OF 1
DATE 06.10.06	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.10.06	DESCRIPTION NEW ISSUE	

RELEASED
06.10.13



D3547-1F FLAT PATTERN

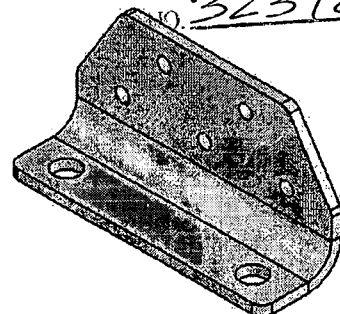


D3547-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3547-1 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32372



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